

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006524**Date Inspected:** 30-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1130**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/30/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4, Japan Steel Works, Muroran, Hokkaido, Japan.

West Deviation Saddles:

W2E3 - Currently section is undergoing preheat due to repositioning following rotation of saddle 180 degrees to gain proper weld position.

W2W1 - Cast is in preparation for fit-up to plate portion in Fabrication Shop #4. One man buttering end of saddle for strongbacks using Shielded Metal Arc Welding (SMAW) 4mm E7016 electrode and procedure SJ-3012-1-2. Individual was H.Mitsumori 81-5438. Procedure and contract documents were adhered to and verified by QC Mr Chung Fu Kuan.

W2W2 - Built up plate portion is welded on one side, awaiting flip of section to allow access to welds in the appropriate position. Cast is still located in Foundry, in storage.

Tower Saddles:

T1-3 - R.Iizuka 06-2643 and M.Kato 08-5018 are depositing root passes on 9S-3U and 9S-2U (respectively), stem plate to stem cast, using Shielded Metal Arc Weld (SMAW) process and 4mm E7016 electrode. NDT Technician Mr Kumagai standing by to perform dry magnetic particle (MT), of root passes. All weld parameters appear to be met at this time.

West Jacking Saddle in located in No 2 Machine Shop undergoing rough machining.

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Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
